

Work Order ID 74437

Thursday, September 29, 2011 2:40:04 PM



Page 1

Item ID: D3275-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 9/29/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 9/29/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3275	Rev A1								
100	Hardinge CNC LATHE SMALL	0.00							
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Turn as per Folio FA469 and Dwg D3275								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

RR
SL 11/10/04

100

RR
SL 11/10/04

100

RR
SL 11/10/05

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



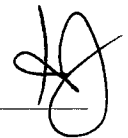
Work Order ID 74437

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Page 2

Item ID: D3275-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Crossbolt Spacer
Start Date: 9/29/2011 Start Qty: 100.00  Cust Item ID:
Required Date: 10/14/2011 Req'd Qty: 100.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <i>LG</i>	0.00				<i>x100</i>			
Packaging	Memo ***STOCK IN SKIDTUBE CELL***	0.00							<i>BE 11/10/05</i>
140  QC	QC21- Final Inspection - Work Order Release	0.00							<i>11/10/11</i> 
Quality Control	Memo	0.00							<i>MF</i> <i>11-10-6</i>

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, September 29, 2011 2:40:11 PM

Page 1

Work Order ID: 74437

Parent Item: D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 9/29/2011

Required Date: 10/14/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A 04.10.19 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05
8

Purchased

No

100

f

116.5390

0.2666

28.06316



ALUM TUBE 3/25 x .058w



SL 11/10/04

Location

Loc Qty

Loc Code

MAT013

116.539

116793

1.667

116939

23.972

117400

28.9

118438 ✓

62

27.416

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74437
Description: Crossbolt Spacer		Part Number: D3275-1
Inspection Dwg: D3275	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+/-0.010	3.186	✓		CNC #2	
0.025 - 0.030	N/A	0.025	✓			
45°	+/-0.01°	45°	✓			
Ø0.313	+0.010/-0.005	0.311	✓			
0.058	Max = 0.0605 Min = 0.0555	0.058	✓			

Measured by: SL RT	Audited by: SA	Prototype Approval:	N/A
Date: 11/10/04	Date: 11/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.19	New Issue	KJ/JLM	
B	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM	
c	09.05.04	Ø0.197 dimension removed	KJ/DD	

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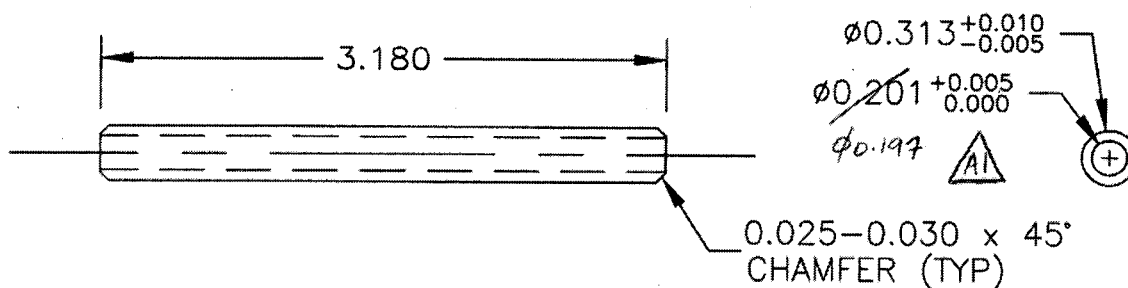


DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>AF</i>	APPROVED	<i>AF</i>	DRAWING NO.	REV. A
				D3275	SHEET 1 OF 1
DATE				TITLE	SCALE
04.03.10				CROSS BOLT SPACER	1:1
A		04.03.10	NEW ISSUE		
AI	<i>CP</i>	04.10.19	CHANGE MAT'L SPEC		

RELEASED
04.06.22

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74437

M.L.J 9/29/11



D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6R) M6061T6T0.313W.058 AI
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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